



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3278-2

Job Sheet 200397



Part No: D3278-2

Job Qty: 80 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/11/19

Job Tracking No:

Due Date: 9/25/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	80 pcs		9/25/19	0.00	4.00	Bandsaw - 1		19-11-08 BM
110	HAAS 5 Axis - B4B	80 pcs		9/25/19	0.06	34.33	HAAS - 5 - B4B		
120	Outsource - 5 - Machining	80 pcs		9/25/19			MEM001-VC		PL 11/13/2019
123	Packaging 2-1 - Receive - B4B	80 pcs		9/25/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		



Container No: S230250



Part: D3278-2

Job No: 200397

Serial No/Batch: S230250

Revision: REV.C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/08/19

NOV 27 2019

Plex 9/11/19 7:41 AM Dart.lajeunesse.marie

					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
126 QC 6	80 pcs	9/25/19	0.00	0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
130 QC 8	80 pcs	9/25/19	0.00	0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
Plex 9/11/19 7:41 AM Dart.lejeunesse.marie						

DAS
81 JAN 07 2020
9-89

DAS
82
9-89

1					QC 8 - 40	JAN 08 2020
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
140	Handfinish - 1-1 Chemical-B4B	80 pcs	9/25/19	0.00 8.24	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	JAN 09 2020
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)-B4B	80 pcs	9/25/19	0.00 1.64	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	80 pcs	9/25/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					Plex 9/11/19 7:41 AM Dart.lajeunesse.marie	

						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	DAS
						QC 3 - 43	81
						QC 3 - 24	9-89
						QC 3 - 61	
						QC 3 - 81	JAN 10 2020
170	Packaging 3-1 - Stock - B4B	80	9/25/19	0.00	0.00	Packaging 3 - 1 - B4B	
	pcs					Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	DAS
						Packaging 3 - 7 - B4B	28
						Packaging 3 - 8 - B4B	9-89
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 -	

Plex 9/11/19 7:41 AM Dart.lajeunesse.marie

					B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	80	9/25/19	0.00	0.00	QC 21 - SA - 21	DAS
	pcs				QC 21 - SA - 70	21
					QC 21 - SA - 53	JAN 13 2020

Part Op 100 - (Bandsaw) Cut blank: 2.00" x 1.00" x 2.550" long
 Descriptions: 110 - (HAAS CNC vertical machine #5)

123 - (Receive & Inspect for Damage & Mat'l Certs)

126 - QC6- All purchased or subcontracted products

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 10:40

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location:) LOCATION : GA

180 - (QC21- Final Inspection - Work Order Release)

M235590
 0.1 T. 800° FINISH; H.P.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	17.3600 ft (.217 ea)	100-Bandsaw - 1	S225343

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.000X02.000	17	41	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	0.098inches	+ 0.005 - 0.000	0.103 0.098	
2	Support	0.359inches	± 0.005	0.364 0.354	
3	Support	0.609inches	± 0.010	0.619 0.599	
4	Support	0.250inches	± 0.010	0.260 0.240	
5	Support	1.480inches	± 0.005	1.485 1.475	
6	Support	0.125inches	± 0.010	0.135 0.115	
7	Support	0.119inches	+ 0.005 - 0.004	0.124 0.115	
8	Support	2.439inches	± 0.010	2.449 2.429	
9	Support	1.980inches	± 0.010	1.990 1.970	
10	Support	0.130inches	± 0.030	0.160 0.100	
11	Support	0.257inches	+ 0.005 - 0.000	0.262 0.257	
12	Support	0.375inches	± 0.010	0.385 0.365	
13	Support	0.875inches	± 0.010	0.885 0.865	
14	Support	0.500inches	± 0.010	0.510 0.490	
15	Support	0.400inches	± 0.010	0.410 0.390	
16	Support	1.000inches	± 0.030	1.030 0.970	
17	Support	1.720inches	± 0.010	1.730 1.710	
18	Support	0.125inches	± 0.010	0.135 0.115	
19	Support	0.125inches	± 0.010	0.135 0.115	

Plex 9/11/19 7:41 AM Dart.lajeunesse.marie



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____		DISPOSITION		DEPARTMENT/PROCESS						MRB (QSI042)									
Part No. _____		Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality									
Date: _____		Sequence #: _____		QTY Affected: _____															
Description Work Order Deviation				Disposition															
												Completed By							
												Lead hand / Supervisor							
												QC / QA Coordinator							
Root Cause				FAULT CATEGORY															
				Operator Manufacturing Process Equipment/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:				Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function				Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045085



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045085

PO Date: 11/13/19

Due Date: 11/25/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200396	D3278-1	D3278 REV.C	Support : Various STC's (Outsource process - Machining)	Firmed	-	11/25/19	80 pcs	0 pcs	80 pcs	\$46.94/pcs	\$3,755.20
Line Item Note: *** NO ALODINE / NO PAINT *** BATCH # S230184												
2	200396	D3278-1	D3278 REV.C	Support : Various STC's	Firmed	-	11/25/19	80 pcs	0 pcs	80 pcs	\$46.94/pcs	\$3,755.20
Line Item Note: *** NO ALODINE / NO PAINT *** BATCH # S230250												
											Grand Total: \$7,510.40	

DA
40
9-89

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/13/19 8:33 AM dart.lussier.patrick



www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 26208
Shipment Date: 25-Nov-2019
Ship Via: Pick up at METEC
Order Number: 4387
Order Date: 11/13/2019

Customer Code: DART
Phone: (613) 632-9577
PO Number: POHB045085
Terms: Net 60 Days

Quantity							
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u> <u>Job Number</u>
1	80	80	0	0	EA	DART-D3278-1P Support, unpainted	C 4387-01
2	80	80	0	0	EA	DART-D3278-2P Support, unpainted	C 4387-02

RECEIVED

NOV 27 2019

DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Weather Dixon

Packing Clerk's Signature
Metec Metal Technology Inc

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
80	D3278-1P	Support	C	S230184	unpainted	HB045085
80	D3278-2P	Support	C	S230250	unpainted	HB045085

DA
40
8-8c

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, November 25, 2019